

July-09-12 9:12:51 AM

Item ID: D3502-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 7/09/12 **Start Qty:** 44.00

44

Cust Item ID:

Required Date: 8/03/12 **Req'd Qty:** 44.00

44

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86876

86876

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12-9-15					
140 *140* Small Fab Small Fab	Small Fab Memo Mark hole position using DT9430Drill as per Dwg D3502.	0.00 0.00				44			12-9-17
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				44			12-9-17

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Item ID: D3502-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Support
Start Date: 7/09/12 Start Qty: 44.00 *44* Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 44.00 *44* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 3:15 FINISH TIME: 3:45	0.00 0.00				44X			MJ 12/09/17
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				44			12-4-17
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: 053 Memo	0.00 0.00				44			12/9/18

M122878

2 /

Dart Aerospace Ltd

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Work Order ID 86876***86876***

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 7/09/12

Start Qty: 44.00

44

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 44.00

44

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/9/18 *[Signature]*

[Signature] 12-09-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

July-09-12 9:12:51 AM

Page 1

Work Order ID: 86876

Parent Item: D3502-1

Parent Item Name: Support

Start Date: 7/09/12

Required Date: 8/03/12

Start Qty: 44.00

Required Qty: 44.00

Comments: IPP Rev:A New Issue 06-07-06 JLM
IPP Rev:B Add tooling hole 07-03-28
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacment Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.000 6061-T6 Bar 1.00 x 4.00		Purchased	No			100	f	91.7185	0.1445	6.6926332		30 12/09/13	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	91.71845	
116808	0.787	
118400	13.48575	
119346	0.1264	
120243	1.57	
120603	1.9435	
120866	12	
121380	25.8058	
121836	12	
122321	24	
→ 122753		

6,7

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Dart Aerospace Ltd

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SHOP COPY

RET

ENG

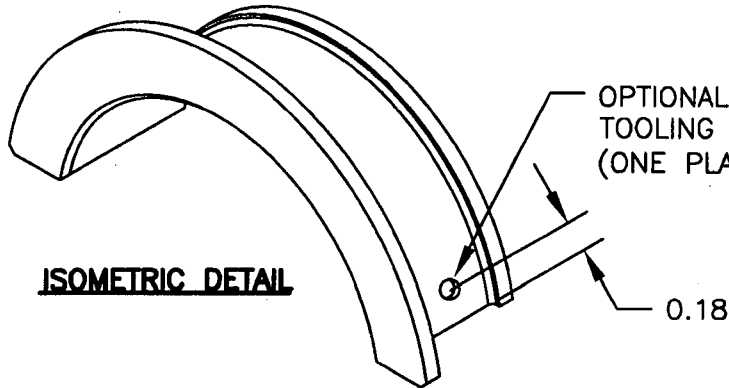
DART

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

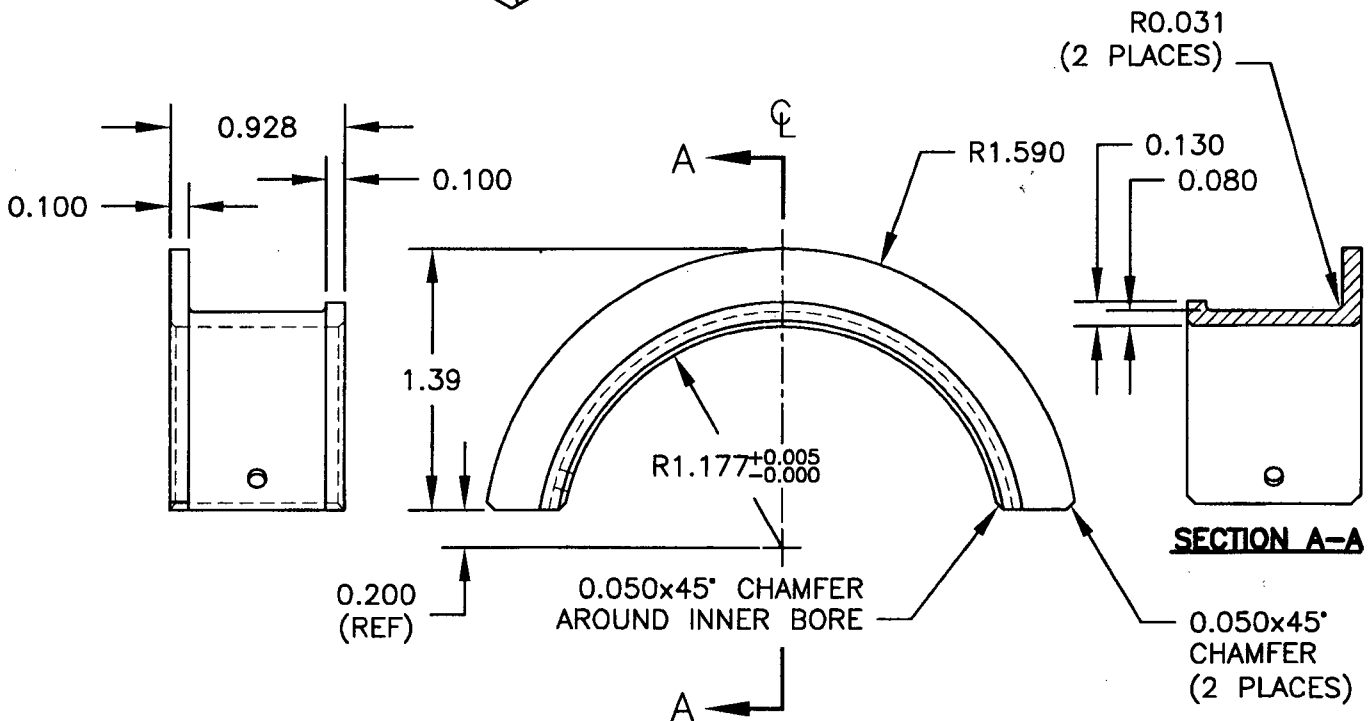
WITHOUT NOTICE
WORK ORDER
NO. 86874

1207-10

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT SCALE 1:1		
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



RELEASED
06.12.06 *qp*
PER ECN 835



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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